

DT 8728

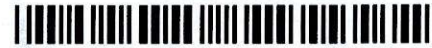


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2939-1

Job Sheet 203788



Part No: D2939-1

Job Qty: 6 pcs

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/19

Job Tracking No:

Due Date: 1/13/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	1/13/20		3.00	6.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		DT 20-02-18
110	Conventional Mill - 1 - B4B	6 pcs	1/13/20		0.00	2.80	Conventional Mill - 1 - B4B		SBL 20/02/20
							Conventional Mill - 2 - B4B		
120	QC 2	6	1/13/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		SBL 20/02/20



Container No: S256604



Part: D2939-1

Job No: 203788

Serial No/Batch: S256604

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/18/20

DART
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
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					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	OK 20/12/21
					QC 8 - 17	
130 QC 8	6 pcs	1/13/20	0.00 0.00		QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	1/13/20	0.00 0.33		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	FEB 21 2020
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	

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150 Powdercoat - 1 White GI(A)- B4B	6 pcs	1/13/20	0.00 0.21	Powdercoat - 1 - B4B	BE B20-02-24
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	6 pcs	1/13/20	0.00 0.00	QC 3 - 10	DAS FEB 25 2020 40 9-89
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	6 pcs	1/13/20	0.00 0.00	Packaging 3 - 1 - B4B	DAS 74 FEB 26 2020 9-89
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

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				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	6 pcs	1/13/20	0.00 0.00	QC 21 - SA - 21	DAS FEB 26 2020
				QC 21 - SA - 70	21
				QC 21 - SA - 53	20

Part Op 100 - (HAAS CNC Vertical Machine) Program part number and batch number. 2-Machine Step No 1 of Folio and visually
 Descriptions: inspect as per dwg D2939 & attached Dimension Sheet
 110 - (Manufacture as per dwg) Machine Keyway and inspect per attached dimension sheet
 120 - Inspect on CMM as per folio CMMA015.
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: R:45 OVEN TEMP: 320° FINISH: 1.15
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

M235590

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	6 pcs (1 ea)	100-HAAS 4 Axis	S235965

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	6	18	0

Part Specifications	
Specifications could not be found.	

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DART AEROSPACE LTD	Work Order: 203788
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.126	0.128	0.125	0.128		
B	0.100	0.140		0.128	0.128	0.127	0.125		
C	0.100	0.140		0.117	0.117	0.118	0.119		
D	0.210	0.230		0.229	0.228	0.228	0.227		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.313	0.313	0.313	0.313		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.117	0.117	0.1175	0.117		
O	0.540	0.560		0.548	0.547	0.547	0.548		
P	0.490	0.510		0.495	0.498	0.498	0.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.744	2.744	2.745	2.745		
S	0.240	0.270		0.260	0.257	0.258	0.259		
T	0.100	0.180		0.133	0.133	0.133	0.132		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.316	0.316	0.316	0.316		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DIP
Date: 20-02-18

Audited by: [Signature]
Date: 20/02/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM [Signature]	[Signature]

DART AEROSPACE LTD	Work Order: 203788
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6			By	Date
A	0.100	0.140		.130	.130				
B	0.100	0.140		.126	.127				
C	0.100	0.140		.117	.118				
D	0.210	0.230		0.228	.227				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.258	0.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.238	.238				
N	0.100	0.140		0.117	.117				
O	0.540	0.560		.547	.546				
P	0.490	0.510		.498	.497				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.745	2.744				
S	0.240	0.270		.261	.261				
T	0.100	0.180		.133	.133				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		0.316	0.316				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585	DT8695 A/B	1.575	1.575				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SBL	Audited by: [Signature]
Date: 20/02/20	Date: 20/02/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM [Signature]	[Signature]